

# Work Order ID 52436

September 23, 2009 2:55:33 PM

Page 1

Item ID: PB67-43001-59

Reference:

Revision ID: B1

Item Name: PB67-43001-59

Start Date: 09/25/2009 Start Qty: 2.00

Cust Item ID:

Required Date: 10/07/2009 Req'd Qty: 2.00

Customer ID:

Customer Name:

Approvals: Process Plan: umf Date: 09-09-23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
B67-43001	Rev B1										
100	Large Fab	Large Fab	0.00	0.00							
		Memo									
		1- to make -105 take M6061T6 tube and fabricate to fit contour of cut□2- Weld -105 to -113 as per dwg and grind weld flush□3- weld 119, -117 and -115 to -113 as per dwg PB67-43001□4- pick two -271 and weld one on each side of tubing but only one need to b									
110	QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00	0.00							
	Quality Control										
		Memo									
120	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control										
		Memo									
130	HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00	0.00							
	Hand Finishing										
		Memo									

CPL 09 09 30

AD 09.09.30

802/60/01

(2)

BLK 09-10-01

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

September 23, 2009 2:55:33 PM

**Reference:**

**Item Name:** PB67-43001-59

**Start Date:** 09/25/2009      **Start Qty:** 2.00

**Cust Item ID:**

**Required Date:** 10/07/2009      **Req'd Qty:** 2.00

**Customer ID:**

**Customer Name:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID	Work Center ID	Operation Description			Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			Set Up	Run							

140 Powdercoat Green Sandtex(Ref:4.3.5.8) per OSI005 4.3

0.00 0.00

## Powder Coating

### Powdercoat

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

## Memo

START TIME: 9:30A - ☐ OVEN  
TEMPERATURE: 320°F ☐ FINISH  
TIME: 10:00A

150	QC	QC3- Inspect Part Finish
-----	----	--------------------------

0.00 0.00

## Quality Control

QC

### QC3- Inspect Part Finish

## Memo

160 Small Fab

0.00                      0.00

### Small Fab

## Small Fab

### Small Fab

## Memo

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001  
 2- deburr and rivet -267 to -113 as per dwg  
 3- assemble rest of parts as per dwg PB67-43001

170	QC	QC5- Inspect part completeness to step on W/O
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0.00	0.00
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## Quality Control

OC

QC5- Inspect part completeness to step on W/O

## Memo

180                      Packaging                      Identify as per dwg & Stock Location:

0.00	0.00
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## Packaging

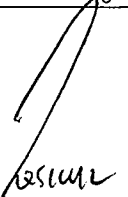
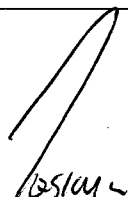


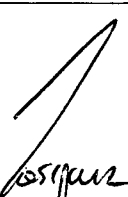
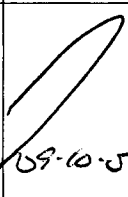
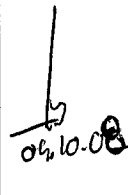
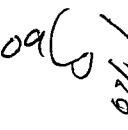
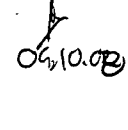
## Packaging

Identify as per dwg & Stock Location:

## Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>01-10-07</del>	<del>110</del>	<del>RECAT ONE PART. SCUFF SCOTCH BRUSH.</del> N/A 02-10-07	<del>BR.</del>	<del>09-10-07</del>	<del>1</del>		

Part No: PB67-43001-59 PAR #: \_\_\_\_\_ Fault Category: Drawing 5 and 11 under review for mods & change NCR: Yes ☒ No ☐ DQA: 7 Date: 05-10-20  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 52436		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/08	#160	Punching assembly PB67-43001-267 one top Bolt. R.C. Process / have to re-bend tabs to install		Scrap AND Destroy Replace PB67-43001-267 Bk <u>44976</u> Qty +1	SAD 09-10-07	S 07/10/08		S 07/10/08
09-10-07	140	1 part needs to be re-coated. part was scratched. R.C. Process. tool slipped		Scrap and re-powder coat per Q51005	BE 09-10-07			
9/10/08		Found that BSP43 rivet is not long enough to cover the hole in 303 45T21 R.C. Process / Design		ADD AN960 303CL to assembly Behind the rivet. AN960 303CL Qty +2 Bk <u>M6959</u>	SAD 09-10-09			S 07/10/08

NOTE: Date &amp; initial all entries

Permit Change  
Rivet

2x DPAT BSP43  
R# B109107

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Cust Item ID:

Required Date: 10/07/2009 Req'd Qty: 2.00

Customer ID:

Customer Name:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID	Work Center ID	Operation Description	Hours		Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			Set Up	Run							
190	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
Quality Control											
Memo											

MF  
09-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 52436

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59

Start Date: 09/25/2009

Required Date: 10/07/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1149F0332P

Purchased

No

100

Each

1,184.000

8.0000



WASHER

SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1184

18057

1184

8

PB67-43001-113RevB1

Manufactured

No

100

Each

2.0000

2.0000



Square Tubing

SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

45256

2

2

PB67-43001-115RevB1

Manufactured

No

100

Each

11.0000

2.0000



Tube End Plate

SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

24807

11

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

September 23, 2009 2:55:33 PM

Work Order ID: 52436

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59

Start Date: 09/25/2009

Required Date: 10/07/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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✓ PB67-43001-117RevB1 Manufactured No



Hook Plate

2.0000



SAD 09-09-28

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

3

41865

3

2

✓ PB67-43001-119RevB1 Manufactured No



End Cap Clevis

100

Each

4.0000

2.0000



SAD 09-09-28

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

4

41478

4

2

✓ PB67-43001-271RevB1 Manufactured No



Doubler

100

Each

20.0000

4.0000



SAD 09-09-28

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

20

41498

1

44975

19

1  
3

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Am760C EL

# Picklist Print

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Work Order ID: 52436



Parent Item: PB67-43001-59RevB1



Parent Item Name: PB67-43001-59

Start Date: 09/25/2009

Required Date: 10/07/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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30345T21		Purchased	No			160	Each	49.0000	4.0000			
✓ LANYARD											SAD	09-09-28

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    49

17828    49

✓ BSP43		Purchased	No			160	Each	142.0000	12.0000			
RIVET											SAD	09-09-28

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    142

109119    42

110704    50

111127    50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 52436

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59


Comments:

Start Date: 09/25/2009

Required Date: 10/07/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			160	f	83.4000	0.3158			
												
6061T6 RDTUBE 1.750 X 0.65W												

SAD 09-09-28

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse

MAT      83.4  
108551      2.24  
109397      4.47  
110885      16.69  
111432      60

~~0.3158~~

MS17984-C413

Purchased

No

160

Each

18.0000

4.0000



PIN, QUICK RELEASE

SAD 09-09-28

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse

ST      18  
109031      10  
111060      8

4

September 23, 2009 2:55:33 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 23, 2009 2:55:33 PM

Work Order ID: 52436

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59


Start Date: 09/25/2009

Required Date: 10/07/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No			160	Each	3,661.000	4.0000			



SAD 09-09-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3661	
110844	32	
111274	137	
111668	992	
112314	2000	
112385	500	

4

MS27039-1-22

Purchased

No

160

Each

30.0000

4.0000



SCREW



SAD 09-09-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	30	
18057	30	

4

PB67-43001-121RevB1

Manufactured

No

160

Each

7.0000

2.0000



Square Sleeve



SAD 09-09-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
43329	7	

2

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 52436



Parent Item: PB67-43001-59RevB1



Parent Item Name: PB67-43001-59

Start Date: 09/25/2009

Required Date: 10/07/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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PB67-43001-267RevB1      Manufactured      No

160

Each

12.0000

2.0000



*SAL 09-09-28*

PB67-43001-267

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

41497

1

44976

11

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

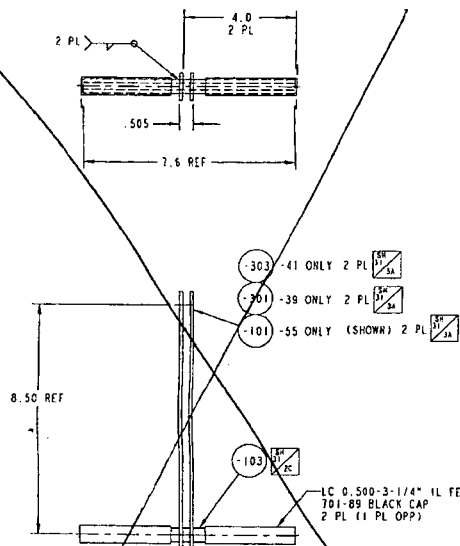
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

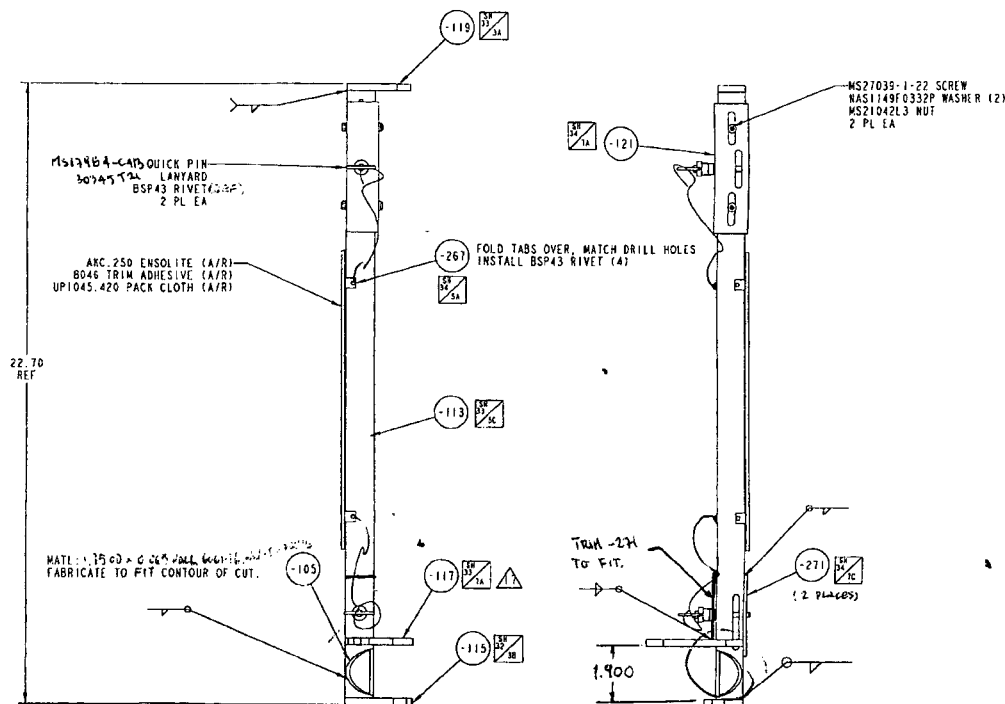
**NOTE:** Date & initial all entries

RELEASED  
# 9.1.2



- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
  - ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
  - ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)
- SCALE 0.500

SUPERSEDED BY  
SUPERSEDED BY **D5451-043/-045/-047**



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY
- SCALE 0.500

52436

**PREMIER AVIATION, INC.**  
3002 Aviation Parkway, Grand Prairie, Texas 75050  
FILE CODE: 867-43001  
Scale: 1:1 SHEET 14 OF 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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